

Work Order ID 66780

Monday, February 28, 2011 8:12:19 AM



Page 1

Item ID: D412-698-019

Accept



Setup Start



Revision ID:

Item Name: Bearing Overhaul

Stop



Start Date: 2/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-02-28 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN D412-698

Rev E

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD412-698-019

CHG001

Sul03/08

Pho →
CL 11-3-9

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/3/85 *(12)*

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

Sul03/08

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D412-698-019 PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: / Date: 11.03.15
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>66780</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/03/08</u>	<u>110</u>	<u>Found that w/o is missing Routin numbers and qty per kit information</u>	<u>CP</u> <u>11.03.09</u> <u>PS 642</u>	<u>→ correctly update w/o to have Rout numbers AND to have the correct Amount under</u>		<u>11.03.09</u>	<u>CP</u> <u>11.03.09</u> <u>PS 642</u>	<u>S</u> <u>11/03/08</u>
		<u>R.c. w/o not created correctly missing info.</u>	<u>CP</u> <u>11.03.09</u>	<u>Qty per kit coloume.</u>	<u>Intuitive error Now fixed</u> <u>11.03.09</u>		<u>CP</u> <u>11.03.09</u>	<u>S</u> <u>11/03/08</u>

NOTE: Date & initial all entries

Work Order ID 66780

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Monday, February 28, 2011 8:12:19 AM

Item ID: D412-698-019

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearing Overhaul

Start Date: 2/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Packaging

11/3/9 J



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-698-019 Location: 31A □ PPP Rev: A

140

0.00



QC21- Final Inspection - Work Order Release

11/3/9 J

QC

Memo

0.00

Quality Control

MF
11-03-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 66780

Parent Item: D412-698-019

Parent Item Name: Bearing Overhaul

Start Date: 2/28/2011

Required Date: 3/7/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B 05-10-12 Pick List Revised KJ/JLM
IPP Rev:C 08-01-28 change to rev D ECN 1104 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
5 D3121-21 Bolt		Manufactured	No				Each	16.0000	77 7	7		11/3/85	
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
ST235								16					
57376								1					
65659								15					
5 D3121-241 Bearing Assembly		Manufactured	No				Each	2.0000	25 5	5		11/3/85	
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
ST235B								2					
65178								2					
6 D3137-3 Guide		Manufactured	No				Each	9.0000	21 1	1		11/3/85	
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
ST235B								9					
63873								2					
65642								7					
6 D3137-5 Washer		Manufactured	No				Each	5.0000	41 1	1		11/3/85	
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
ST235B								5					
65365								4					
66102								1					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, February 28, 2011 8:12:27 AM

Page 2

Work Order ID: 66780

Parent Item: D412-698-019

Parent Item Name: Bearing Overhaul

Start Date: 2/28/2011

Required Date: 3/7/2011

Start Qty: 1.00

Required Qty: 1.00

D3183-045

Manufactured No

Each

2.0000

+2



Bearing Assembly



2
367028 11/3/85

Location

Loc Qty

Loc Code

ST236

2

63989

2

MS24694-S101

Purchased

No

Each

39.0000

+1



Screw



1
11/3/85

Location

Loc Qty

Loc Code

ST290A

39

.110363

39

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Part Number	Description
X						D412-698-011	CABIN DOOR ROLLER KIT, LH
	X					D412-698-012	CABIN DOOR ROLLER KIT, RH
		X				D412-698-013	DOOR HANDLE KIT
			X			D412-698-017	REPLACEMENT DOOR TRACK KIT
				X		D412-698-019	BEARING OVERHAUL KIT
					X	D412-698-021	REPLACEMENT SHIM KIT
3	3					D3121-141	BRACKET ASSEMBLY
1						D3121-143	BRACKET ASSEMBLY
	1					D3121-144	BRACKET ASSEMBLY
1	1					D3137-043	BRACKET ASSEMBLY
1						D3183-043	BRACKET ASSEMBLY
	1					D3183-044	BRACKET ASSEMBLY
9	9		9			D3199-1	BRACKET
1	1		1			D3202-1	COVER
		4				D3203-1	HANDLE
		1				D3220-041	DOUBLER
		1				D3220-042	DOUBLER
		2				D3220-3	DOUBLER
				7		D3121-21	BOLT
				5		D3121-241	BEARING ASSEMBLY
				1		D3137-3	GUIDE
				1		D3137-5	WASHER
				2		D3183-045	BEARING ASSEMBLY
					3	D3238-1	SHIM
					1	D3238-3	SHIM
					2	D3238-5	SHIM
					6	D3238-11	SHIM
					2	D3238-13	SHIM
					4	D3238-15	SHIM
		8				AN960JD416L	WASHER
		8				MS21042L4	NUT (OR MS21042-4)
		16				MS24694-S98	SCREW
				1		MS24694-S101	SCREW

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Revision: **E**
Date: 08.05.01